



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D5770-041
Job Sheet 207406

NO 20.02.20



Part No: D5770-041

Job Qty: 2 pcs

Part Name: Attachment Hoop



Part Weight: 0 lbs

Job Created: 2/25/20

Due Date: 3/6/20

Type: Stock

Status: New

Job Tracking No:

Created By: Jennifer Renwick

Description:

POSITIVE RECALL

EFFECTIVE _____ AUTH _____

RELEASED _____ DATE _____

Priority: Medium

Note: URF 20-522 DWG D5770 REV.A IPP REV:A NEW ISSUE 20.01.14 JV VERF:DD

Ship Via:

Bill of Materials

Job Routing

| Op No | Operation | Qty | Start Date | Due Date | Standard Setup Hrs | Run Hrs | Workcenter/Supplier | Lead Time | Sign-off |
|-------|-----------------------|-----|------------|----------|--------------------|---------|-----------------------|-----------|----------|
| 100 | Conventional Mill - 1 | 2 | | 3/6/20 | 0.25 | 0.67 | Conventional Mill - 1 | | |
| | | pcs | | | | | Conventional Mill - 2 | | |
| 110 | QC 2 | 2 | | 3/6/20 | 0.00 | 0.00 | QC 2 - 1 | | |
| | | pcs | | | | | QC 2 - 12 | | |
| | | | | | | | QC 2 - 14 | | |
| | | | | | | | QC 2 - 17 | | |
| | | | | | | | QC 2 - 19 | | |
| | | | | | | | QC 2 - 2 | | |
| | | | | | | | QC 2 - 20 | | |
| | | | | | | | QC 2 - 22 | | |
| | | | | | | | QC 2 - 23 | | |
| | | | | | | | QC 2 - 25 | | |
| | | | | | | | QC 2 - 32 | | |
| | | | | | | | QC 2 - 33 | | |
| | | | | | | | QC 2 - 35 | | |
| | | | | | | | QC 2 - 39 | | |
| | | | | | | | QC 2 - 4 | | |
| | | | | | | | QC 2 - 40 | | |
| | | | | | | | QC 2 - 44 | | |
| | | | | | | | QC 2 - 45 | | |
| | | | | | | | QC 2 - 48 | | |
| | | | | | | | QC 2 - 49 | | |
| | | | | | | | QC 2 - 50 | | |
| | | | | | | | QC 2 - 51 | | |
| | | | | | | | QC 2 - 52 | | |
| | | | | | | | QC 2 - 57 | | |
| | | | | | | | QC 2 - 62 | | |
| | | | | | | | QC 2 - 63 | | |
| | | | | | | | QC 2 - 8 | | |
| | | | | | | | QC 2 - 66 | | |
| | | | | | | | QC 2 - 64 | | |

PRIORITY



Container No: S259708



Part: D5770-041

Job No: 207406

Serial No/Batch: S259708

Revision: REV.A

Inspector:

Exp Date:

Instructions:

Dart
1270 -
Hawkesbury
CANADA
TEL.: 1 613 632-5200
Email: sales@dart.com
www.dartaerospace.com

Date:

Plex 2/26/20 10:03 AM Dart.lajeunesse.marie

| | | | | | |
|-------------------------------|----------|--------|-----------|-----------------------------------|--|
| 120 QC 5 | 2 pcs | 3/6/20 | 0.00 0.00 | QC 2 - 65 | |
| | | | | QC 2 - 5 | |
| | | | | QC 2 - 71 | |
| | | | | QC 2 - 73 | |
| | | | | QC 2 - 69 | |
| | | | | QC 2 - 76 | |
| | | | | QC 8 - 12 | |
| | | | | QC 8 - 14 | |
| | | | | QC 8 - 17 | |
| | | | | QC 8 - 20 | |
| | | | | QC 8 - 25 | |
| | | | | QC 8 - 3 | |
| | | | | QC 8 - 32 | |
| | | | | QC 8 - 33 | |
| | | | | QC 8 - 35 | |
| | | | | QC 8 - 39 | |
| | | | | QC 8 - 4 | |
| | | | | QC 8 - 44 | |
| | | | | QC 8 - 45 | |
| | | | | QC 8 - 49 | |
| | | | | QC 8 - 58 | |
| | | | | QC 8 - 8 | |
| | | | | QC 8 - 9 | |
| | | | | QC 8 - 68 | |
| | | | | QC 8 - 67 | |
| | | | | QC 8 - 1 (A) | |
| | | | | QC 8 - 47 | |
| | | | | QC 8 - 40 | |
| | | | | QC 8 - 52 | |
| | | | | QC 8 - 23 | |
| | | | | QC 8 - 57 | |
| | | | | QC 8 - 76 | |
| | | | | QC 8 - 61 | |
| 130 Large Fab - Welded Assy-1 | 2 pcs | 3/6/20 | 0.00 1.00 | Large Fab - 1 - B4B | |
| | | | | Large Fab - 10 - B4B | |
| | | | | Large Fab - 2 - B4B | |
| | | | | Large Fab - 3 - B4B | |
| | | | | Large Fab - 4 - B4B | |
| | | | | Large Fab - 5 - B4B | |
| | | | | Large Fab - 6 - B4B | |
| | | | | Large Fab - 7 - B4B | |
| | | | | Large Fab - 8 - B4B | |
| | | | | Large Fab - 9 - B4B | |
| | | | | Large Fab - 11 - B4B (Various) | |
| | | | | Large Fab - 12 - B4B | |
| | | | | | |
| 140 QC 9 | 2 pcs | 3/6/20 | 0.00 0.00 | QC 9 - 10 | |
| | | | | QC 9 - 18 | |
| | | | | QC 9 - 24 | |
| | | | | QC 9 - 43 | |
| | | | | QC 9 - 50 | |
| | | | | QC 9 - 9 | |
| 150 QC 5 | 2 pcs | 3/6/20 | 0.00 0.00 | QC 5 - 10 | |
| | | | | QC 5 - 12 | |
| | | | | QC 5 - 17 | |
| | | | | QC 5 - 18 | |
| | | | | QC 5 - 19 | |
| | | | | QC 5 - 22 | |
| | | | | QC 5 - 24 | |

m/20/03/02

DAS
24
9-39DAS
43
9-39

| | | | | | |
|-----|-----------------------------|-------|--------|-----------|------------------------|
| | | | | QC 5 - 3 | DAG |
| | | | | QC 5 - 43 | 43 |
| | | | | QC 5 - 49 | 9-89 |
| | | | | QC 5 - 51 | |
| | | | | QC 5 - 56 | |
| | | | | QC 5 - 68 | |
| | | | | QC 5 - 9 | |
| | | | | QC 5 - 50 | |
| | | | | QC 5 - 30 | |
| | | | | QC 5 - 40 | |
| | | | | QC 5 - 61 | |
| | | | | QC 5 - 81 | |
| 160 | Packaging 3-1 - Stock - B4B | 2 pcs | 3/6/20 | 0.00 0.00 | Packaging 3 - 1 - B4B |
| | | | | | Packaging 3 - 2 - B4B |
| | | | | | Packaging 3 - 3 - B4B |
| | | | | | Packaging 3 - 4 - B4B |
| | | | | | Packaging 3 - 5 - B4B |
| | | | | | Packaging 3 - 6 - B4B |
| | | | | | Packaging 3 - 7 - B4B |
| | | | | | Packaging 3 - 8 - B4B |
| | | | | | Packaging 3 - 9 - B4B |
| | | | | | Packaging 3 - 10 - B4B |
| | | | | | Packaging 3 - 11 - B4B |
| | | | | | Packaging 3 - 12 - B4B |
| | | | | | Packaging 3 - 13 - B4B |
| | | | | | Packaging 3 - 14 - B4B |
| | | | | | Packaging 3 - 15 - B4B |
| | | | | | Packaging 3 - 16 - B4B |
| | | | | | Packaging 3 - 17 - B4B |
| | | | | | Packaging 3 - 18 - B4B |
| | | | | | Packaging 3 - 19 - B4B |
| | | | | | Packaging 3 - 20 - B4B |
| | | | | | Packaging 3 - 21 - B4B |
| | | | | | Packaging 3 - 22 - B4B |
| | | | | | Packaging 3 - 23 - B4B |
| | | | | | Packaging 3 - 24 - B4B |
| | | | | | Packaging 3 - 25 - B4B |
| | | | | | Packaging 3 - 26 - B4B |
| | | | | | Packaging 3 - 27 - B4B |
| | | | | | Packaging 3 - 28 - B4B |
| | | | | | Packaging 3 - 29 - B4B |
| | | | | | Packaging 3 - 30 - B4B |
| | | | | | Packaging 3 - 31 - B4B |
| | | | | | Packaging 3 - 32 - B4B |
| | | | | | Packaging 3 - 33 - B4B |
| | | | | | Packaging 3 - 34 - B4B |
| | | | | | Packaging 3 - 35 - B4B |
| | | | | | Packaging 3 - 36 - B4B |
| | | | | | Packaging 3 - 37 - B4B |
| 170 | QC 21 - SA | 2 pcs | 3/6/20 | 0.00 0.00 | QC 21 - SA - 21 |
| | | | | | QC 21 - SA - 70 |
| | | | | | QC 21 - SA - 53 |

Part Op 100 - 1-Start with D5770-5 hoop as stock. 2-Machine as per drawing see sheet 3 detail C. 3-Deburr

Descriptions: 110 - QC2- Inspect parts off machine FAI/FAIB

120 - QC8- Inspect parts - second check

130 - 1-Attach two D5770-7 lugs to 11.000" spacing jig DT *CPA* using 3/8-24 bolt. Align lugs to slots in hoop prepared in step 1. Centre as per view A-A sheet 1. 2-Weld as per sheet 1. A/R 4430 rod Batch: 137070

140 - QC9- Inspect visual per QSI004- Fusion Welds

150 - QC5- Inspect part completeness to step on W/O

160 - Identify as per dwg & Stock Location: _____, See note 6.
 170 - QC21- Final Inspection - Work Order Release

Job BOM

| Part / Item | Component Name | Quantity | Operation | Container |
|-------------|----------------|--------------|-------------------------------|-----------|
| D5770-5 | Hoop | 2 pcs (1 ea) | 100-Conventional Mill - 1 | S259556-1 |
| D5770-7 | Lug | 4 pcs (2 ea) | 130-Large Fab - Welded Assy-1 | S259494 |

Job Allocations

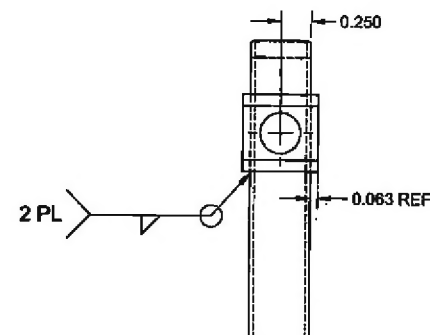
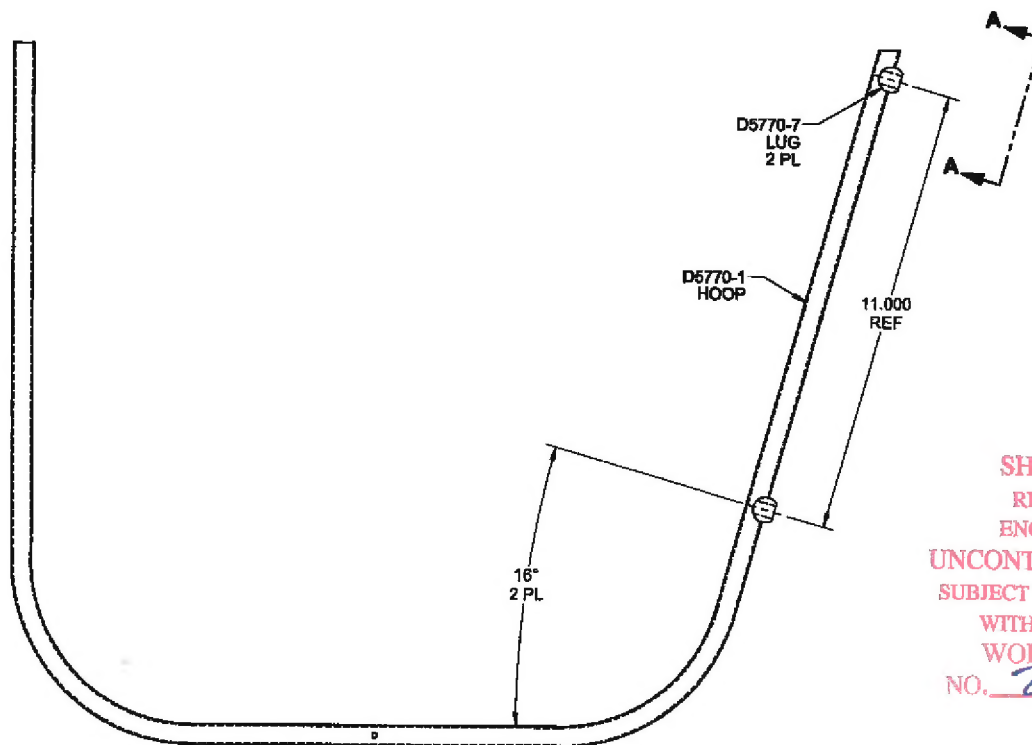
| Operation | Component Part | Required | Inventory | Allocated |
|-------------------------------|----------------|----------|-----------|-----------|
| 100-Conventional Mill - 1 | D5770-5 | 2 | 0 | 0 |
| 130-Large Fab - Welded Assy-1 | D5770-7 | 4 | 0 | 0 |

Part Specifications

Specifications could not be found.

Plex 2/26/20 10:03 AM Dart.lajeunesse.marie

| QTY -041 | P/N | DESCRIPTION |
|-------------|-----------|-----------------|
| X | D5770-041 | ATTACHMENT HOOP |
| 1 | D5770-1 | HOOP |
| 2 | D5770-7 | LUG |



VIEW A-A
SCALE 3X, 2 PL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 207406 MJS
2002-26

D5770-041 ATTACHMENT HOOP
(DERIVED FROM AERO DESIGN P/N 76422-01)

UNDER REVIEW
URF 2020-522 20.02.14 (NO)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY PER DART QSI 044
 - 7) WEIGHT: 0.91 lbs
 - 8) WELD PER DART QSI 004

RELEASED
2020 FEB 18
ECN 2020-521

APPROVED

| REV. | DESCRIPTION | BY | DATE |
|------------|-------------|----|----------|
| A | NEW ISSUE | ZF | 20.01.09 |
| DESIGN | ZF | | |
| DRAWN | ZF | | |
| CHECKED | KPT | | |
| MFG. APPR. | DD | | |
| APPROVED | NO | | |
| DE APPR. | CP | | |
| DATE | 20.01.09 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D5770

TITLE
BASKET HOOPS

REV. A
SHEET 1 OF 7
SCALE
NTS

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

| | | | | | |
|--|---|--|--|------------------------|--|
| Job: _____ Part No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> | DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> </div> <div> Eng. (Non-AW) <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div> | | | |
| Date : | Sequence #: | QTY Affected : | | MRB (QSI042) | |
| Description Work Order Deviation | | Disposition | | Completed By | |
| | | | | Lead hand / Supervisor | |
| | | | | | |
| | | | | | |
| Root Cause Operator <input type="checkbox"/> Manufacturing Process <input type="checkbox"/> Equip/Tooling <input type="checkbox"/> Handling/Presservation <input type="checkbox"/> Material <input type="checkbox"/> Product Improvement <input type="checkbox"/> Process Improvement <input type="checkbox"/> Human Factors <input type="checkbox"/> | | FAULT CATEGORY <div style="display: flex; justify-content: space-between;"> <div> <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Bending <input type="checkbox"/> Crushing <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Mislabeled </div> <div> <input type="checkbox"/> Contamination <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Incomplete/Unclear Instructions <input type="checkbox"/> Drill Holes <input type="checkbox"/> Fit/Function </div> <div> <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain Direction <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Off-set/Set-up </div> <div> <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Outside Tolerance <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Misread </div> </div> | | | |
| Other/Details: | | | | | |